

chp 20/08

Date: Wednesday, 06/08/2008 2:06:11 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SUPPORT ASSY (LH)
Job Number :	41019	Part Number :	D3699041
Estimate Number :	13285	Drawing Number :	D3699 REVA
P.O. Number :		Project Number :	N/A
This Issue :	06/08/2008	Drawing Revision :	A
Prsht Rev. :	NC	Material :	
First Issue :	1/1	Due Date :	28/08/2008
Previous Run :	38872	Qty:	5/2 Um: Each
Written By :			
Checked & Approved By :	JUD 08.8.06		
Comment :	Est Rev:A 08-04-25 new issue DD verified by:ec Est Rev:B 08-07-14 revA as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
-----	-------------	--------------------



2.5



Comment: Qty.: 0.4797 sf(s)/Unit Total : 0.9595 sf(s)
 6061T6 aluminium sheet .050" thick
 (M6061T6S050)
 Batch: 104186 B 8-8-7

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3699
 Dwg Rev: A B 8-8-7
 Prog Rev: A
 ***grain direction along 9.00" ***
 2- Deburr if necessary B 8-8-7

7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 8-8-7



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/08/07 17

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Bend as per Dwg D3697

SB 08/08/12

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:06:11 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (LH)

Job Number: 41019

Part Number: D3699041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (X7)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink holes as per dwg D3699

FF 08-08-14

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-14 (7)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-08-18

10.0

POWDER COATING

POWDER COATING



M 102 316



(7X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15
3:20
3:45

M-L 08/08/18

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-18 (14)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

13.0

MS21059L3

Nut Plate



(7X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut Plate

batch:

M106042

8/8/19

SL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:06:11 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (LH)

Job Number: 41019

Part Number: D3699041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS20426AD33

Rivet



6

Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
Rivet

M1563

8/8/19

30

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3699

8/8/08/20 6 (72)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 02/03/20 (72)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST385 184

02/08/121

(7)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2019

Job Completion



MF 08-08-21

Dart Aerospace Ltd

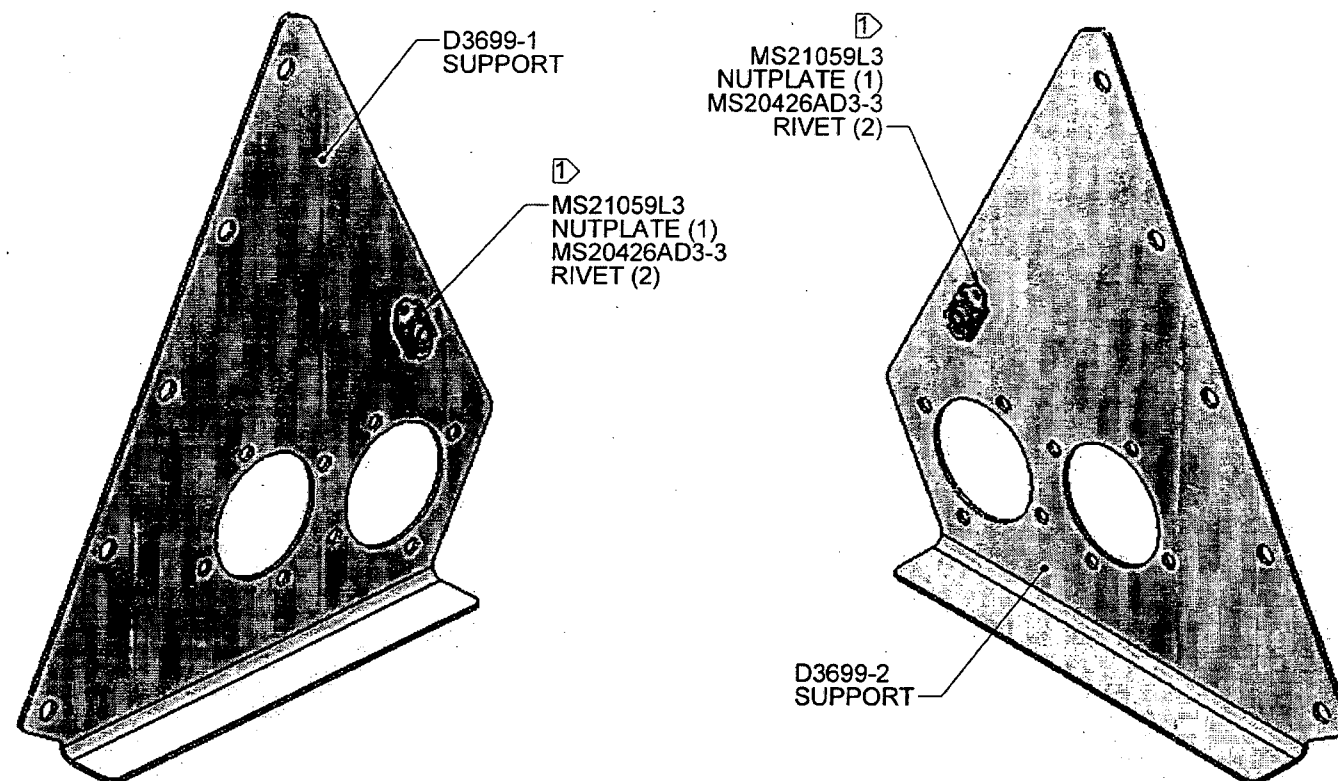
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3699-041 SUPPORT ASSEMBLY

D3699-042 SUPPORT ASSEMBLY

NOTES:

- 1) INSTALL MS21059L3 NUTPLATE USING C'SINK $\phi 0.098$ HOLES ON D3699-1/-2
- 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699-041/-042 & B/N USING FINE POINT PERMANENT INK MARKER
- 3) WEIGHT: 0.17 lb EACH

PART LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

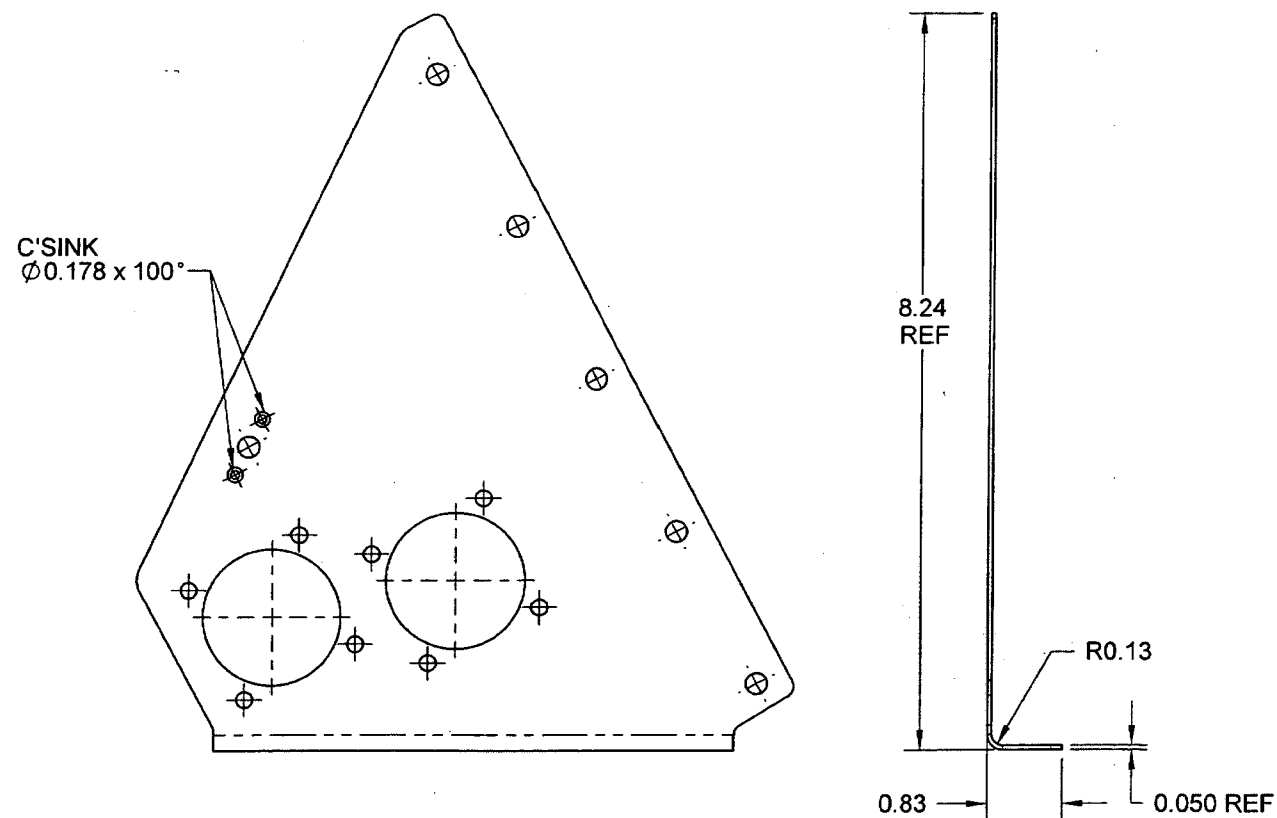
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08.07.12

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WITHOUT NOTICE
WORK ORDER
NO. 44019

A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	TH		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	AS	D3699	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	TH	SUPPORT ASSEMBLY	NTS
DATE	08.05.12	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

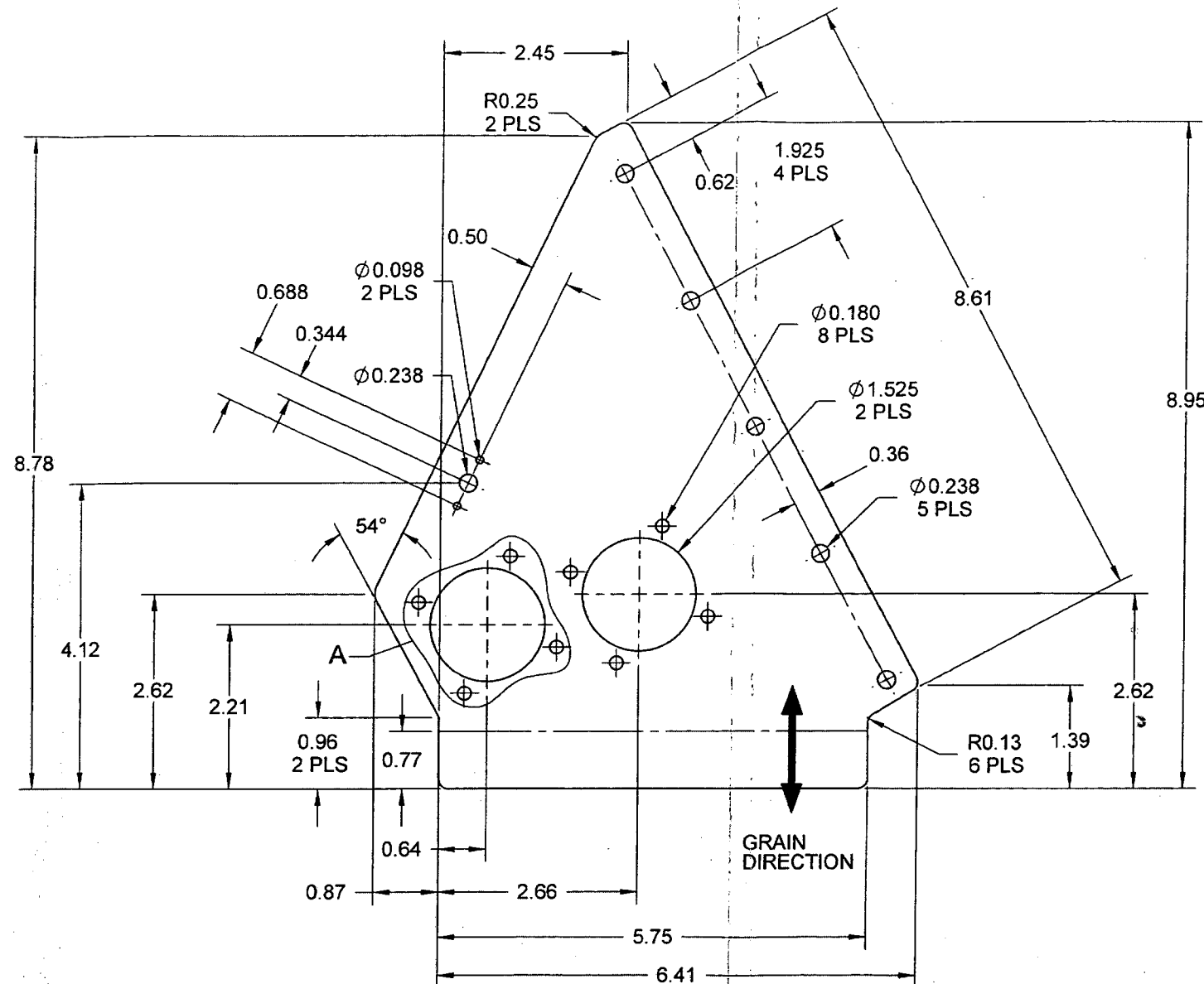
D3699-1 LH SUPPORT

D3699-2 RH SUPPORT

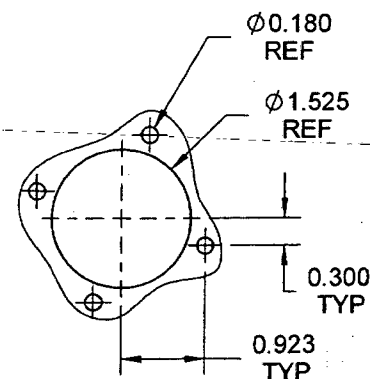


**D3699-1 SUPPORT, LH SHOWN
(D3699-2 SUPPORT, RH OPPOSITE)
(MAKE FROM D3699-1F FLAT PATTERN)**

- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK
(REF. DART SPEC. M2024T3S.050 OR M6061T6S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.17 lbs



D3699-1F FLAT PATTERN



DETAIL A

RELEASED
08-07-08

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WORK ORDER
NO. 41019

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3699	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ASSEMBLY	NTS
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DART AEROSPACE LTD		Work Order: 41019
Description: SUPPORT ASSY		Part Number: D3699-1
Inspection Dwg: D3699-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	X			
Ø .180	+ .005 - .001	.183	X			
Ø .238	+ .005 - .001	.242	X			
Ø 1.525	+ .012 - .001	1.529	X			
.36	± .030	.363	X			
.62	± .030	.62	X			
.96	± .030	.96	X			
2.21	± .030	2.21	X			
4.12	± .030	4.12	X			
8.95	± .030	8.95	X			
1.925	± .010	1.925	X			
8.61	± .030	8.61	X			
2.62	± .030	2.62	X			
.344	± .010	.344	X			
.688	± .010	.688	X			
.64	± .030	.64	X			
2.66	± .030	2.66	X			
5.75	± .030	5.750	X			
6.41	± .030	6.413	X			
.300	± .010	.301	X			
.923	± .010	.923	X			
.050	± .010	.054	X			

Measured by: LB	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 8-8-7	Date: 8/8/8	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

P/O D 3699-041

[Signature]